

Work Order ID 135750

135750

Page 1

Tuesday, August 18, 2015 2:30:59 PM

Item ID: D4154-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Assembly

Start Date: 8/18/2015 Start Qty: 6.00

~~*6*~~

Cust Item ID:

Required Date: 8/18/2015 Req'd Qty: 6.00

~~*6*~~

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: MLS

Date: AUG 19 2015

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4154

E

100

0.00

100

Large Fab

Large Fab

Memo

0.00

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

DT9756

2059 B Hardcoat Welding Rod

BATCH#: 130145

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH #: 128077

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

5- Cut extra material on back end of wearplate if necessary

4

15-10-28

ML

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Item ID: D4154-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 8/18/2015 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 8/18/2015 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC5- Inspect part completeness to step on W/O	0.00				(4)			DAS 38 9-89
160									
QC	Memo	0.00							
Quality Control									OCT 30 2015

170	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									OCT 30 2015

130151030

Picklist Print

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Work Order ID: 135750

135750

Parent Item: D4154-041

D4154-041

Parent Item Name: Wearplate Assembly

Start Date: 8/18/2015

Required Date: 8/18/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC IPP Rev:B
10.11.04 added DT9684 DD verf:EC IPP Rev:C 11.04.14 as
per dwg revB DD verf:EC IPP Rev:D 12.09.14 as per dwg
revE DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4154-1		Manufactured	No			100	Each	15.0000	1	6			
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D4154-1

Plate

15-10-26
JAL

Location

Loc Qty

Loc Code

WA001

15

129759

5

130516

10

D4155-1

Manufactured No

100

Each

10.0000

1

6

D4155-1

Bar

15-10-26
JAL

Location

Loc Qty

Loc Code

WA001

6

130098

6

WA002

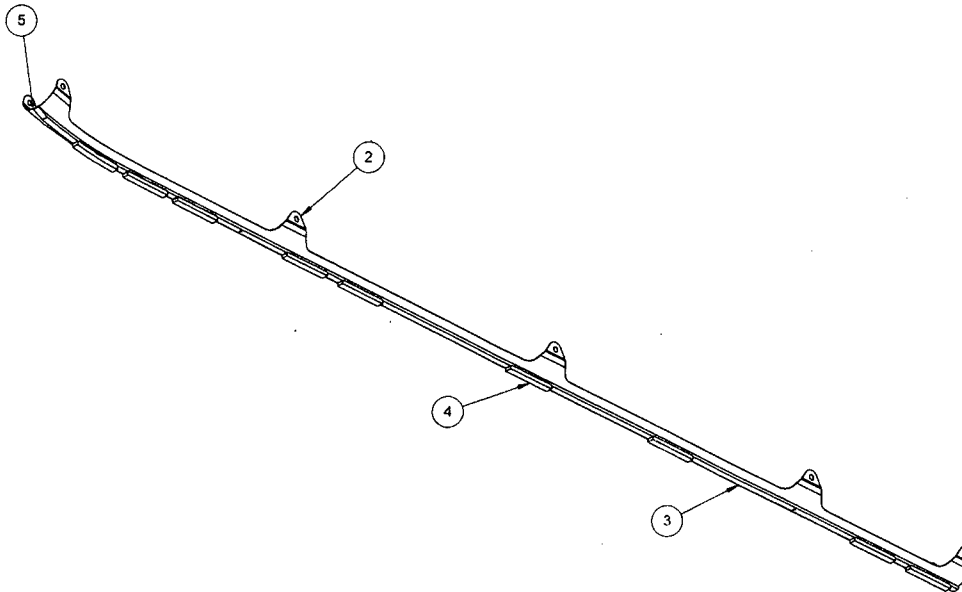
136570

4

129059

4

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4154-041	WEARPLATE ASSEMBLY
2	1	D4154-1	PLATE
3	1	D4155-1	BAR
4	A/R	2059B	HARDCOAT, (SEE NOTE 9, SHT 2)
5	A/R	4714	(SEE NOTE 11, SHT2)

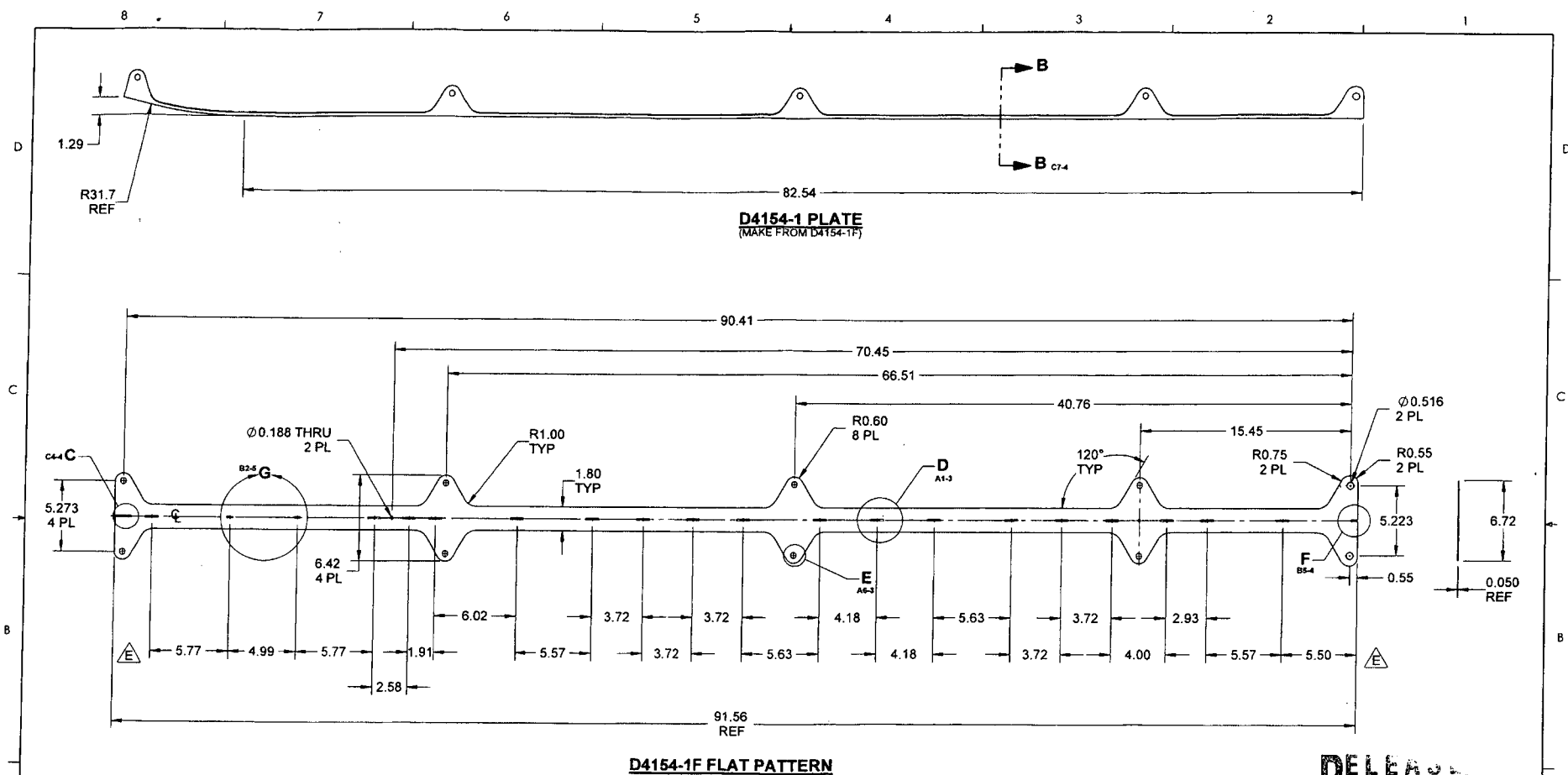


D4154-041 WEARPLATE ASSEMBLY

135750 MJS
1508-18

RELEASED
2012-09-04

E	SHT 3 SLOTS RE-PITCHED (PAR 12-213); 0.32 WAS 0.37	AJS	12.08.07
D	70.45 WAS 74.45 & Ø 0.188 HOLES NOW 2 PL (ZN C4-3 & C7-3)	RF	12.05.03
C	REVISE NOTE 9 (ZN A8-2); ADD HARDCOAT (ZN B7-2); ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AJS		
CHECKED	SP	DRAWING NO.	REV. E
MFG. APPR.	12	D4154	SHEET 1 OF 4
APPROVED	12	TITLE	SCALE
DE APPR.	12	WEARPLATE ASSEMBLY	NTS
DATE	12.08.07	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

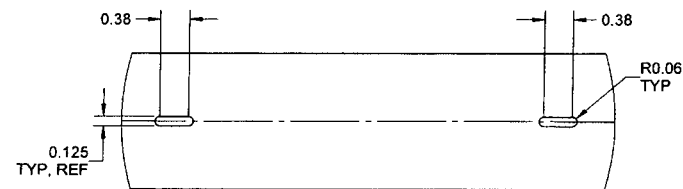
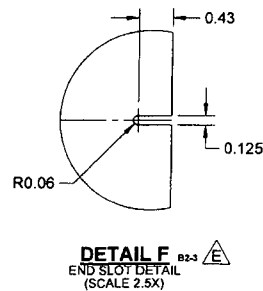
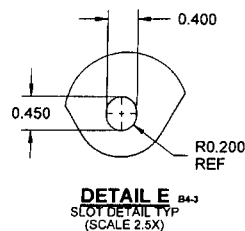
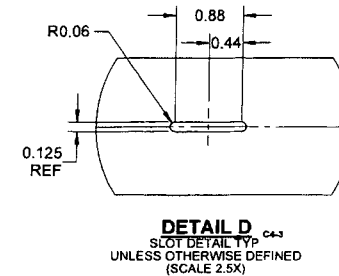
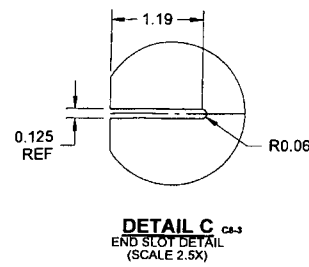
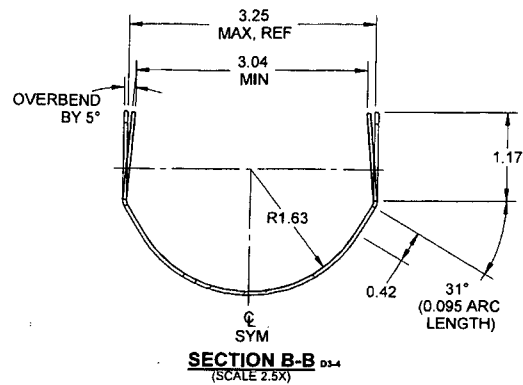


RELEASE
2012-09-04
MD

NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.95 lbs

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CHECKED	JP	DRAWING NO.	REV. E
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2012-09-04
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